

September-24-13 11:04:13 AM

Item ID: D3805-045

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Wearplate Ass'y Aft Low Gear

Start Date: 9/24/13 **Start Qty:** 2.00 ***2***

Cust Item ID:

Required Date: 9/25/13 **Req'd Qty:** 2.00 ***?***

Customer: CU-DAR001

Reference: RMA RA111566 - RETURN

Approvals: Process Plan: Date: Tooling: Date:

Run Start *NR1*

QC: Date: SPC (Y/N): Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3805	B

0.00

100

QC

Quality Control

Memo

INSPECT RA111566
2 X D3805-045 B92298

0.00

DAS
16
9-89

13/10/03

110

0.00

110

HandFinish

Hand Finishing

Memo

STRIP PARTS COMPLETELY

0.00

2 MB 974

120

0.00

120

Large Fab

Large Fab

Memo

STEP 2 ON RS1012

0.00

2 R 13-9-28

Work Order ID 107426

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Page 2

Item ID: D3805-045 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Wearplate Ass'Y Aft Low Gear
Start Date: 9/24/13 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 9/25/13 Req'd Qty: 2.00 ***2*** Customer: CU-DAR001
Reference: RMA RA111566

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC9- Inspect visual per QS1004- Fusion Welds	0.00							
130									
QC	Memo	0.00							
Quality Control									
140	QC5- Inspect part completeness to step on W/O	0.00							
140									
QC	Memo	0.00							
Quality Control									
150		0.00							
150									
QC	Memo	0.00							
Quality Control	SCA INSPECTION								

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Item ID: D3805-045 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Wearplate Ass'Y Aft Low Gear
Start Date: 9/24/13 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 9/25/13 Req'd Qty: 2.00 ***2*** Customer: CU-DAR001
Reference: RMA RA111566

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160		0.00							
160									
Powdercoat	Memo	0.00							
Powder Coating	RE-POWDER COAT ORANGE PER QSI005 4.3								
	START TIME: 2:30								
	OVEN TEMP: 320								
	FINISH TIME: 3:00								
170	QC3- Inspect Part Finish	0.00							
170									
QC	Memo	0.00							
Quality Control									

W112243

2x7 M/L 13/09/26

2x E Ill 13/09/26

2

Work Order ID 107426

September-24-13 11:04:13 AM

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Page 4

Item ID:	D3805-045	Accept	*N900040100*	Setup	Start	*NS1*
Revision ID:					Stop	*NS2*
Item Name:	Wearplate Ass'Y Aft Low Gear					
Start Date:	9/24/13	Start Qty: 2.00	*2*	Cust Item ID:		
Required Date:	9/25/13	Req'd Qty: 2.00	*2*	Customer:	CU-DAR001	
Reference:	RMA RA111566					

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	*NR1*
	QC:	Date:	SPC (Y/N):	Date:		Stop	*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180		0.00							
180									
Small Fab	Memo	0.00							
Small Fab	INSTALL RUBBER GASKET PER DRWG D3805 WITH 3M SCOTCH GRIP ADHESIVE								
	D3807-5 B <u>105190</u>								
	A/R 3M SCOTCH GRIP ADHESIVE								
	B <u>124297</u>								
190	QC5- Inspect part completeness to step on W/O	0.00							
190									
QC	Memo	0.00							
Quality Control									
200		0.00							
200									
Packaging	Memo	0.00							
Packaging									

2x 13/09/27

DAS
27
9-89
139 07

2 13-10-03

Work Order ID 107426

September-24-13 11:04:13 AM

107426

Page 5

Item ID: D3805-045 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Wearplate Ass'Y Aft Low Gear
Start Date: 9/24/13 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 9/25/13 Req'd Qty: 2.00 ***2*** Customer: CU-DAR001
Reference: RMA RA111566

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210		0.00			DAS				
210					16				
QC		0.00			9-89				
Quality Control	Memo SCA INSPECTION, COMPELTE MAINTENANCE RELEASE ACCORDING TO QSI 016					13/10/03			

Handwritten notes:
DAS 29 9-89
MF 13-10-03

Picklist Print

September-24-13 11:01:41 AM

Page 1

Work Order ID: 107426

Parent Item: D3805-045

Parent Item Name: Wearplate Ass'y Aft Low Gear

Start Date: 9/24/13

Required Date: 9/25/13

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-12-01 new issue EC verified by:DD IPP Rev:B 09-03-04 rev.a as per dwg
DD verified by:EC IPP Rev:C 11.10.04 rev.b as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3805-045		Manufactured	No				Each	24.0000			2	9/23/09/27	
Wearplate Ass'y Aft Low Gear													

Location	Loc Qty	Loc Code
FP001	18	
93652	3	
93653	2	
93654	6	
93731	5	
96004	2	
FP002	6	
73817	1	
74896	1	
87186	4	

D3807-5

Gasket

Manufactured No

Each 37.0000

Location	Loc Qty	Loc Code
GA	37	
104423	1	
105190	29	
90485	1	
92779	1	
93684	5	

B/107426
(22)

2

DART AEROSPACE LTD	Work Order:	107426
Description: Repair damaged training wearplate from FT. Rucker (AFT Batch:92298) (FWD Batch:92297)		D3805-045
Drawing: D3805	Repair Scheme:	RS1012
Part No: D3805-045 D3805-041	Page:	1 of 1
Batch No:	Qty:	2 ea.

Step	Location	Procedure	By	Date	Qty
1	Finishing	1- Remove all powdercoat from wearplate			
2	Large Fab	1- Inspect Wearplates for damage according to ICA D206-642 Rev. 5. 2- Install damaged wearplate on welding fixture 3- Re-weld area where weld is missing and repair cracks as per QSI 004 A/R S.S. Rod Batch: M126588 M126588-2057B 4- Re-form wear plate on welding fixture	EL	13.9.25	2
3	QC	QC9	DAS 09	13.09.25	2
4	QC	QC5	09	13.09.25	2
5	QC	SCA inspection	29	13.09.26	2
6	Powdercoat	Powdercoat Orange QSI 005 4.3 START TIME: 2:30 OVEN TEMPERATURE: 320°F FINISH TIME: 3:00 M12243	M13/09/26		2
7	QC	QC3	ll	13/09/26	2
8	Small Fab	Install rubber gasket as per dwg D3805 with 3M scotch grip adhesive D3807-5 Gasket Batch: B105190 D3807-3 Gasket Batch: B105189 A/R 3M scotch grip adhesive Batch: M124297	LB	13/09/27	2
9	QC	QC5			
10	Packaging	Identify and stock			
11	QC	SCA inspection complete Maintenance Release according to QSI 016.	28	13.10.03	2

Rev	Date	Change Description	Prepared	Checked	Approved
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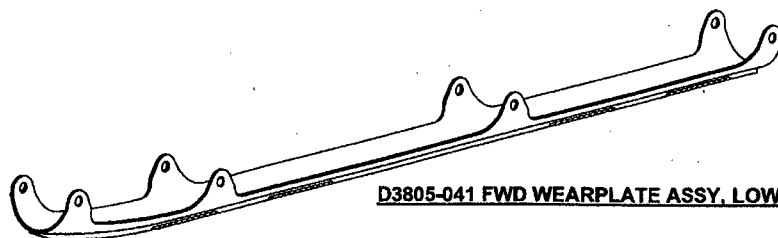
DART AEROSPACE LTD	Work Order:	107427
Description: Repair damaged training wearplate from FT. Rucker (AFT Batch:92298) (FWD Batch:92297)		
Drawing: D3805	Repair Scheme:	RS1012
Part No: D3805-045 D3805-043	Page:	2 of 1
Batch No:	Qty:	2 ea.

A	11.04.06	New Issue	DD		
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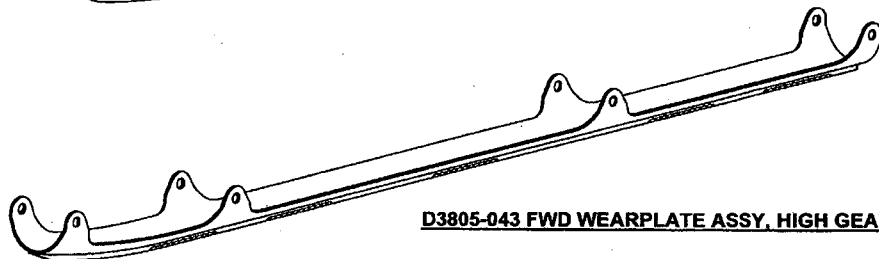
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Rev. A

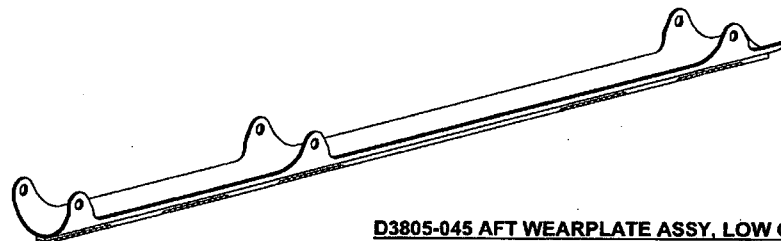
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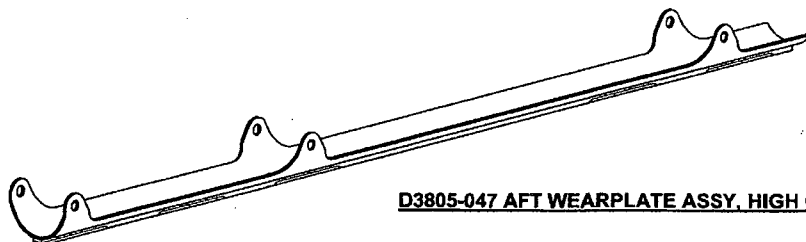
D3805-041 FWD WEARPLATE ASSY, LOW GEAR



D3805-043 FWD WEARPLATE ASSY, HIGH GEAR



D3805-045 AFT WEARPLATE ASSY, LOW GEAR



D3805-047 AFT WEARPLATE ASSY, HIGH GEAR

8 7 6 5 4

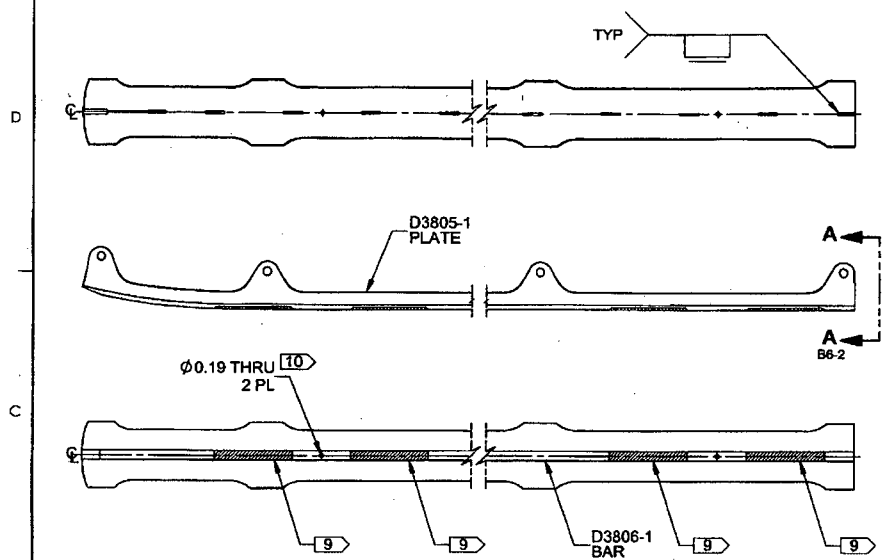
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1	X				D3805-041	FWD WEARPLATE ASSY, LOW GEAR
2		X			D3805-043	FWD WEARPLATE ASSY, HIGH GEAR
3			X		D3805-045	AFT WEARPLATE ASSY, LOW GEAR
4				X	D3805-047	AFT WEARPLATE ASSY, HIGH GEAR
11	1				D3805-1	PLATE
12		1			D3805-3	PLATE
13			1		D3805-5	PLATE
14				1	D3805-7	PLATE
15	1				D3806-1	BAR
16		1			D3806-3	BAR
17			1		D3806-5	BAR
18				1	D3806-7	BAR
19	1				D3807-1	GASKET
20		1			D3807-3	GASKET
21			1		D3807-5	GASKET
22				1	D3807-7	GASKET
31	A/R	A/R	A/R	A/R	2059B	HARDCOAT
32	A/R	A/R	A/R	A/R	1300 (OR 1300L)	3M SCOTCH-GRIP ADHESIVE

4 13-10-3
107426

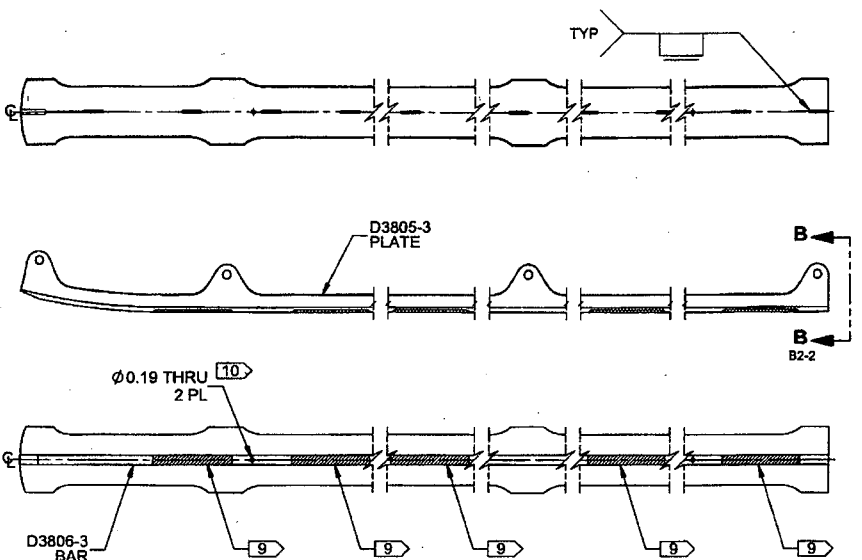
RELEASED
2011-10-03
MB

B	REVISED D3805-1F/3F TO EASE MANUFACTURABILITY (ADDED CUTOUT AT FWD END OF PLATE PER PART 11-108) AND RE-ORGANIZED NOTES SHEETS 2 & 3		MB	11.09.16
A	NEW ISSUE		MB	08.11.21
REV.	DESCRIPTION		BY	DATE
DESIGN	97		DART AEROSPACE USA, INC.	
DRAWN	11		KENT, WA	
CHECKED	11		REV. B	
MFG. APPR.	11		D3805 SHEET 1 OF 8	
APPROVED	11		TITLE SCALE	
DE APPR.	11		WEARPLATE ASSY NTS	
DATE	11.09.16		COPYRIGHT © 2008 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

8 7 6 5 4 3 2 1



D3805-041 FWD WEARPLATE ASSY, LOW GEAR

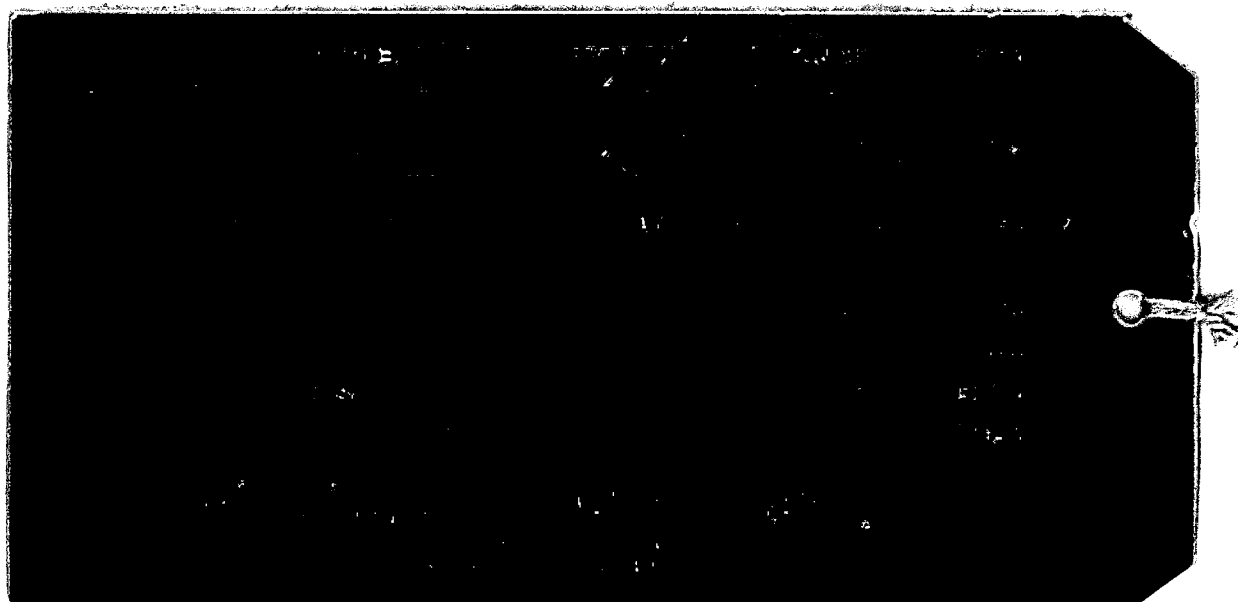
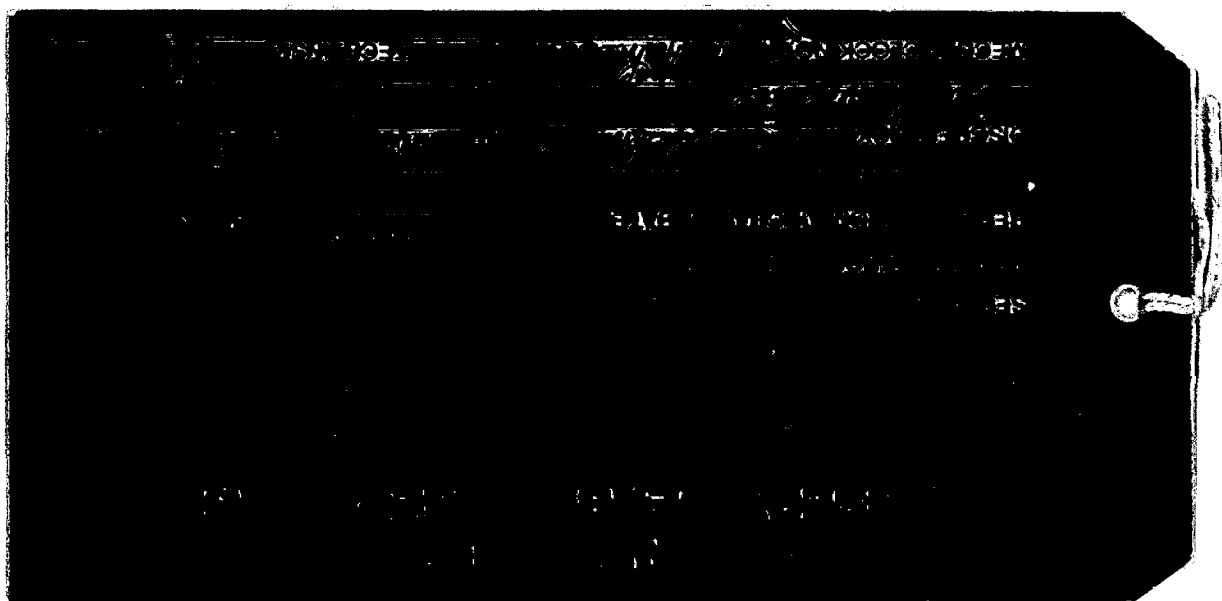


D3805-043 FWD WEARPLATE ASSY, HIGH GEAR


107427
RELEASED
2011-10-03
ND

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3805-04X" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: D3805-041 = 4.18 lbs; D3805-043 = 4.78 lbs
 - 8) WELDING: PER QSI 004
 - 9) 2059B HARDCOAT WELD, 0.19 THICK X 0.50 WIDE, FLUSH WITH D3806-X BAR ON ALL 3 SURFACES
 - 10) AFTER WELDING, TRANSFER DRILL THRU BAR FROM PLATE
 - 11) AFTER FINISH, BOND D3807-X GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3805	SHEET 2 OF 8
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
DATE	11.09.16	<small>COPYRIGHT © 2008 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	



**NTH ONLY
UNSERVICEABLE - REPAIRABLE**

MFG. DART TSN: _____
MODEL TH67 TSO: _____
PART NO. D3805-045
SERIAL NO. N/A
NOMENCLATURE AFT wear Plate Assy
REMOVED FROM AIRCRAFT & DATE: 7939 - 1495.5 hrs on Shores
DISCREPANCY: LTP Evaluation / Rubber missing
MECH. & CLOCK NO. Jept A Pmace 446T TECH. INSP. 

**NTH ONLY
UNSERVICEABLE - REPAIRABLE**

MFG. DART TSN: _____
MODEL TH67 TSO: _____
PART NO. D3805-045
SERIAL NO. N/A
NOMENCLATURE AFT wear plate Assy
REMOVED FROM AIRCRAFT & DATE: 7939 - 1495.5 hrs on Shores
DISCREPANCY: LTP Evaluation / Rubber Missing
MECH. & CLOCK NO. Jept A Pmace 446T TECH. INSP. 